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NOTES:


1. IDENTIFY IAW MPP-120.
2. DEBURR AND BREAK ALL SHARP EDGES. 45 CHAMFER .015" TO .030" AROUND PART EXTERIOR EDGES.
3. FINISH: BRUSHED
4. DEBURR AND BREAK ALL SHARP EDGES. 45 CHAMFER .005" TO .010" AROUND PART EXTERIOR EDGE.
5. MATERIAL: 301 STAINLESS STEEL PER AMS 5518, .0625 THICK (16 GAUGE)
6. MATERIAL: 301 STAINLESS STEEL PER AMS 5518, .125 THICK (11 GAUGE)
7. PART GEOMETRY AND HOLE LOCATION DIMENSIONS CONTROLLED BY CAD MODEL.
FORMAT FILE NAME AS:
652.84XX(PART NUMBER) XXX(REVISION LEVEL) XXXXXXXX(DESCRIPTION) XX-XX-XX (DATE)
8. 100% LOT INSPECTION, CRITICAL FEATURE.
9. SCORE SURFACE USING 40 GRIT SAND PAPER.
10. PRIMER FINISH: PC 4426, MANUFACTURER: ROYAL ADHESIVES & SEALANTS. FOR ASSY'S 652.8401- .8402
PRIMER AFTER ASSY HAS BEEN ADHERED.
11. ENSURE ALL HOLES ARE CONCENTRIC. ADHERE GIRT STRIPS USING F/N 15. ADHESIVE SHOULD BE AT ROOM TEMP PRIOR TO MIXING. APPLY THIN LAYER ACROSS ENTIRE SURFACE AND LET CURE FOR 24 HOURS.
12. MANUFACTURER: RESINLAB. P/N AR4315.

PROTOTYPE REVISIONS							
ZONE	REV.	DESCRIPTION	DATE	APPROVED	EFF.	RC	REVISED
ALL	PR1	INITIAL RELEASE	10-16-19	J.GARDINER	-	-	-
ALL	PR2	UPDATED DIMENSIONS AND NOMENCLATURE, REMOVED PN 652.8412 AND 652.8416, ADDED PN 652.8426 AND 652.8427	11-07-19	R. TAKAHASHI	CURRENT ORDER	DE	T. ARANDA
ALL	PR3	REMOVED 652.8426 AND 652.8427, REMOVED DELETED ITEMS FROM BOM, ADDED CHAMFER TO ALL EDGES, ADDED CHAMFER TO CURVED FWD GIRT BAR	02-10-20	R. TAKAHASHI	NEXT ORDER	DE	A. FLORES
SHT2, 3, 4, 5	PR4	HOLE SPACING CHANGED ON 652.8410 AND 652.8414 DUE TO QUARTUS FWD POD CHANGES, ADDED MISSING DIMENSIONS, UPDATED EDGE DISTANCE AND HOLE CENTER TO AVOID CLASH ON POD FEATURES	03-24-20	J. GARDINER	NEXT ORDER	DE	R. TAKAHASHI, NICK R.
ALL	PR5	REVISED NOTES 1, 2, 4, 5, & 6. ADDED NOTES 8-12. ADDED ASSY .8401 - .8403 TO BOM AND VIEWS ON SHEET 5. RESIVED MATL OF FN 1, 3, & 7. ADDED FN 15	02-03-21	T. CROSS T.C.	NEXT ORDER	DE	A. FLORES

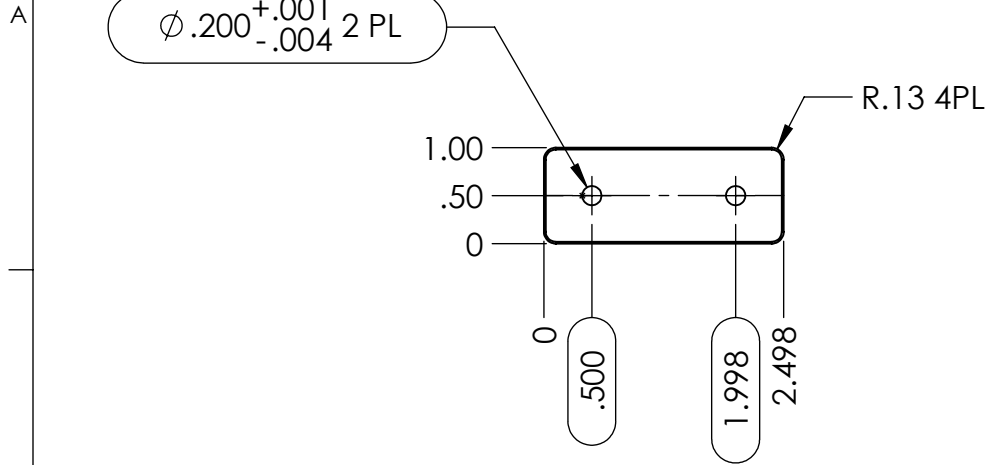
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
		MM-DD-YY	J. GARDINER

PR5

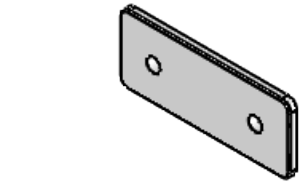
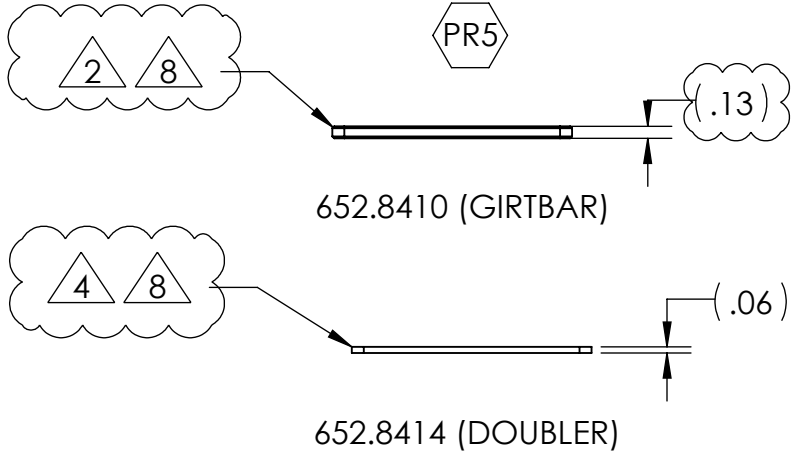
A/R	A/R	A/R	15	600.1000	ADHESIVE	5	12
			14	652.8425	DOUBLER 4 HOLE BF (AFT)	5	3 9
			13	652.8424	GIRT STRIP 4 HOLE BF (AFT)	6	3 9 10
			12	652.8423	DOUBLER 3 HOLE TF (FWD)	5	3 9
			11	652.8422	GIRT STRIP 3 HOLE TF (FWD)	6	3 9 10
			10	652.8421	DOUBLER 3 HOLE TF (AFT)	5	3 9
			9	652.8420	GIRT STRIP 3 HOLE TF (AFT)	6	3 9 10
1			8	652.8419	DOUBLER 3 HOLE (AFT)	5	3 9
1			7	652.8418	GIRT STRIP 3 HOLE (AFT)	6	3 9
	1		6	652.8417	CURVED DOUBLER 3 HOLE (FWD)	5	3 9
			5	652.8415	DOUBLER 3 HOLE BF (FWD)	5	3 9
		1	4	652.8414	DOUBLER 2 HOLE (FWD)	5	3 9
	1		3	652.8413	CURVED GIRT STRIP 3 HOLE (FWD)	6	3 9
			2	652.8411	GIRT STRIP 3 HOLE BF (FWD)	6	3 9 10
		1	1	652.8410	GIRT STRIP 2 HOLE (FWD)	6	3 9
X				652.8403	GIRT ASSY 3 HOLE (AFT)		10 11
	X			652.8402	CURVED GIRT ASSY 3 HOLE (FWD)		10 11
		X		652.8401	GIRT ASSY 2 HOLE (FWD)		10 11
.8403	.8402	.8401	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY		PARTS LIST			
<div>NEXT ASSY (S)</div> <div>652.7500</div>		ORIGINAL DATE (MO-DA-YR) 10-16-19		<div> 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300</div> <div>APICAL INDUSTRIES, INC. dba DART AEROSPACE</div>	
		DRAWN BY NICK R.	CHECKER CHAYSE Z.		
		DRAWING APPROVAL J. GARDINER 10-16-19			
		CONTRACT No.			
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°			
		AW189 SHEET METAL			
		SIZE B	CAGE CODE 07M26	DWG. NO. 652.8400	REV. PR5
		SCALE NONE		SHEET 1 OF 5	

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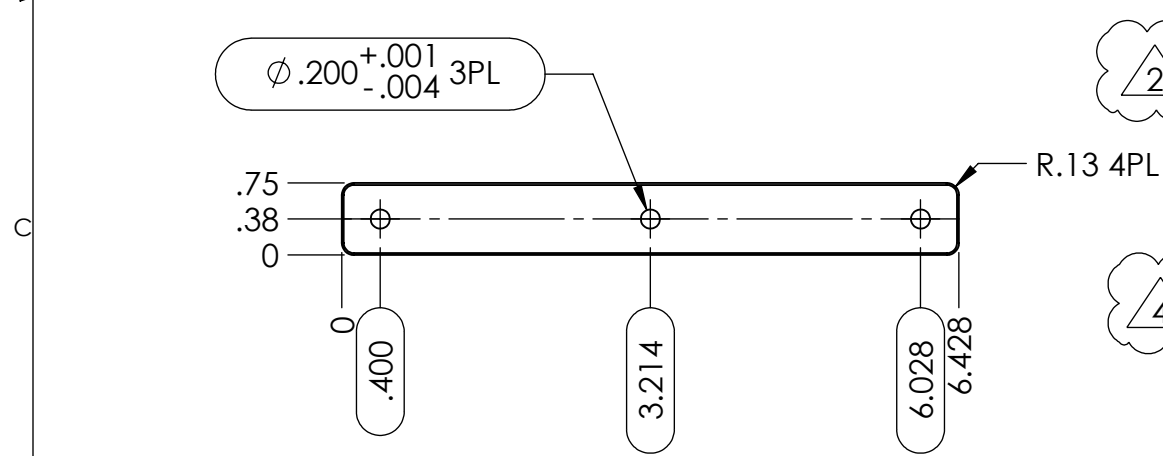


TOP VIEW 652.8410 & 652.8414

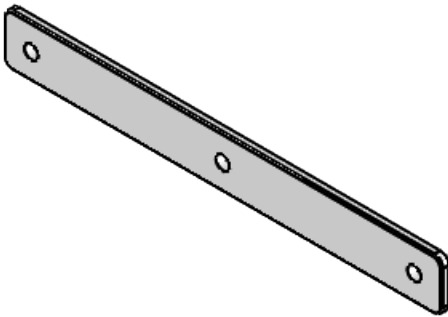


652.8410 SHOWN
652.8414 SIMILAR

1 4



TOP VIEW 652.8411 & 652.8415



652.8411 SHOWN
652.8415 SIMILAR

2 5

D

ORIGINAL DATE (MO-DA-YR) 10-16-19	DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300		
DRAWN BY NICK R.			
CHECKER CHAYSE Z.			
DRAWING APPROVAL J. GARDINER 10-16-19	AW189 SHEET METAL		
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$	SIZE B	CAGE CODE 07MZ6	DWG. NO. 652.8400
	SCALE NONE	SHEET 2 OF 5	REV. PR5

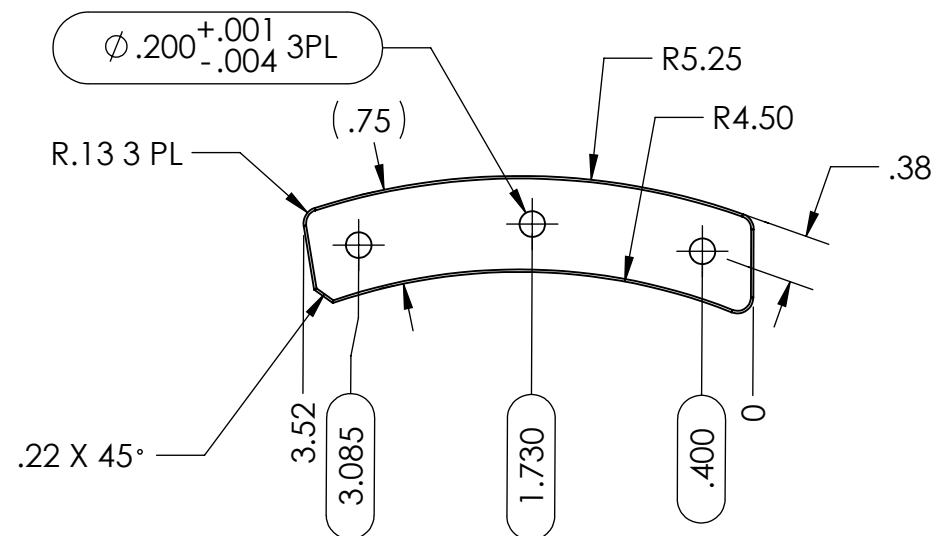
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A

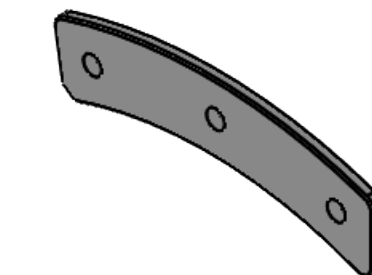
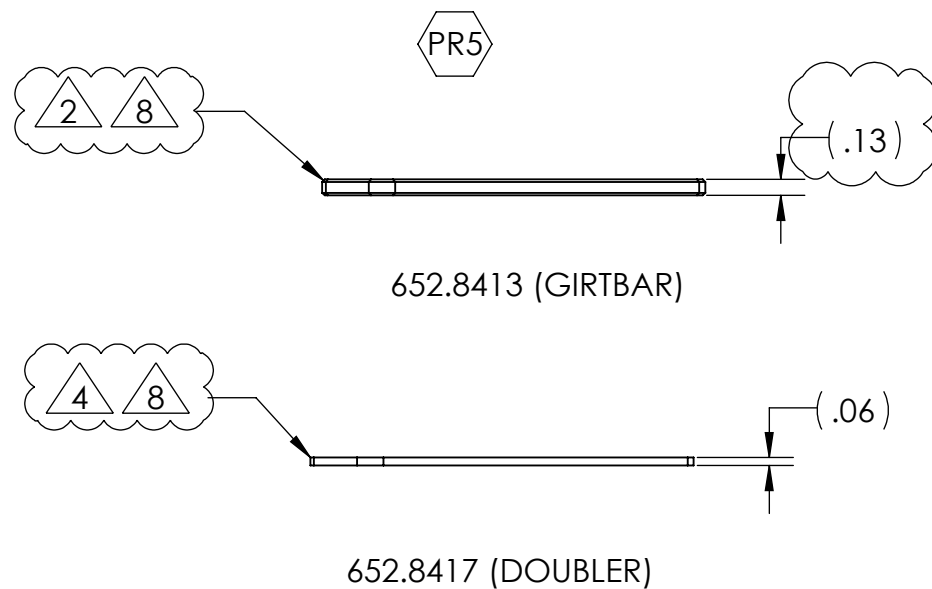
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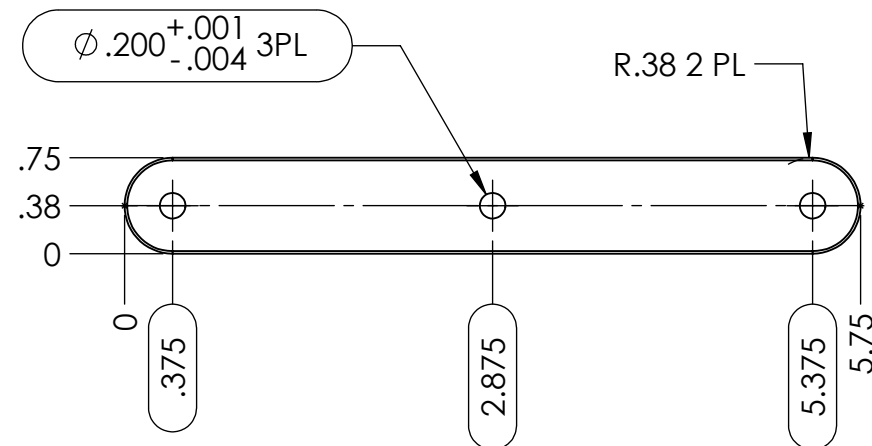


TOP VIEW 652.8413 & 652.8417

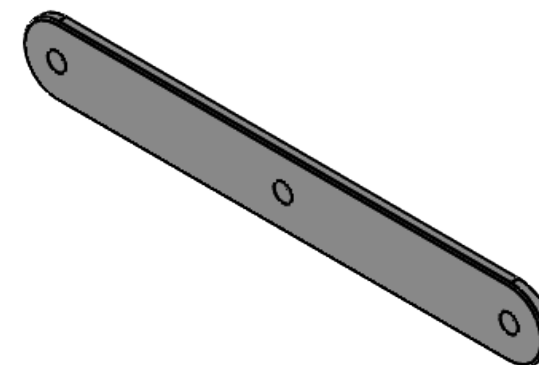
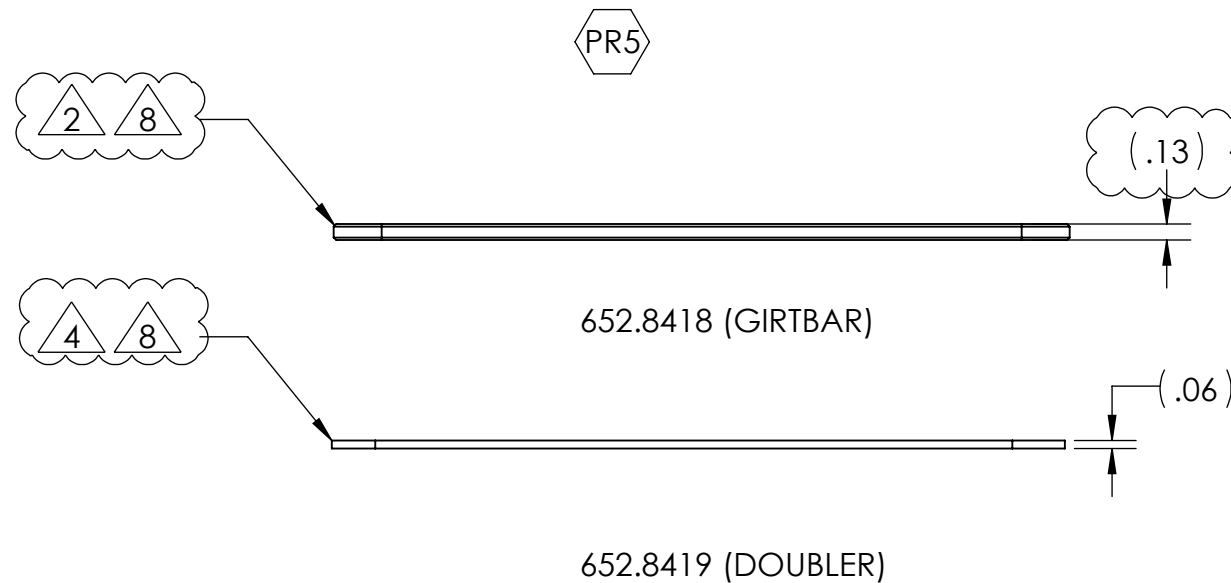


652.8413 SHOWN
652.8417 SIMILAR

3 6



TOP VIEW 652.8418 & 652.8419



652.8418 SHOWN
652.8419 SIMILAR

7 8

ORIGINAL DATE (MO-DA-YR) 10-16-19		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY NICK R.	CHECKER CHAYSE Z.		
DRAWING APPROVAL J. GARDINER 10-16-19		APICAL INDUSTRIES, INC. dba DART AEROSPACE	
CONTRACT No.		AW189 SHEET METAL	
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		CAGE CODE 07MZ6	DWG. NO. 652.8400
		SCALE NONE	SHEET 3 OF 5

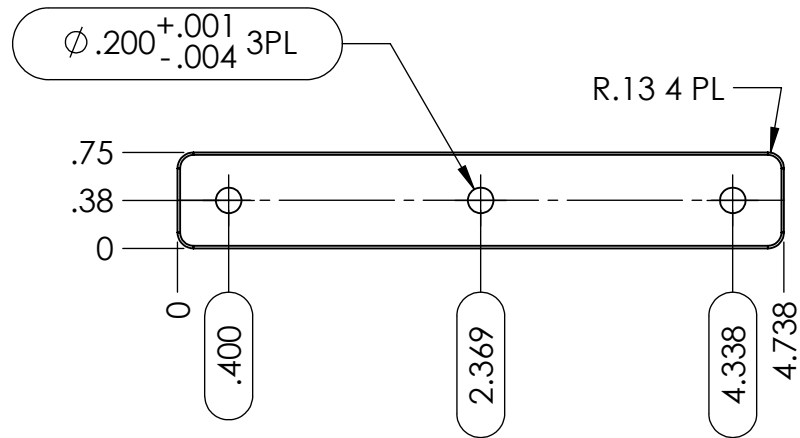
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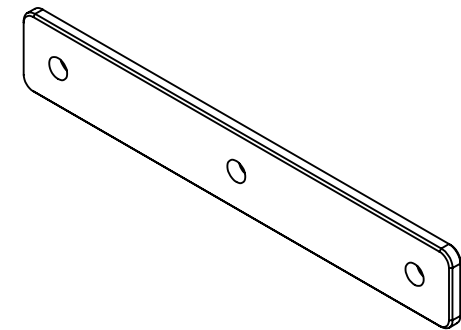
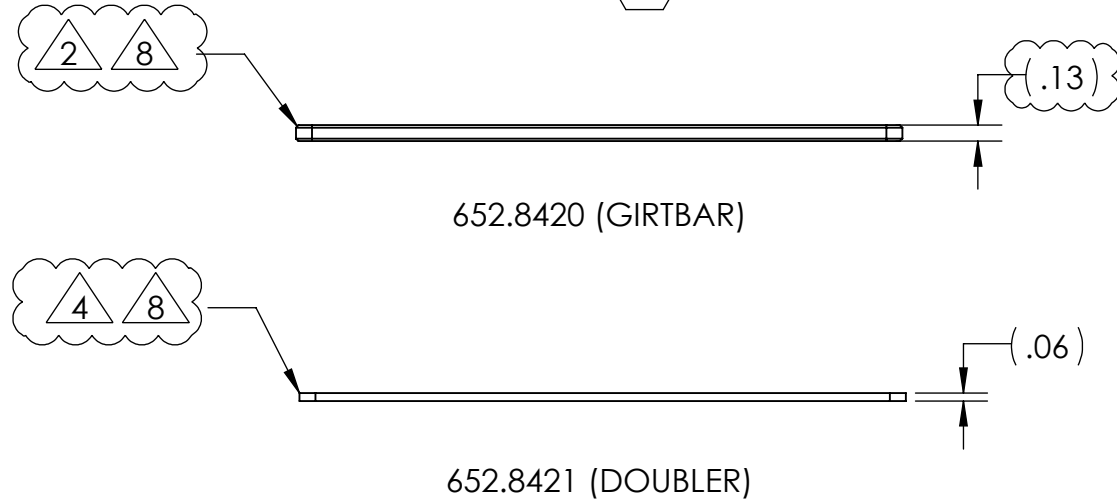
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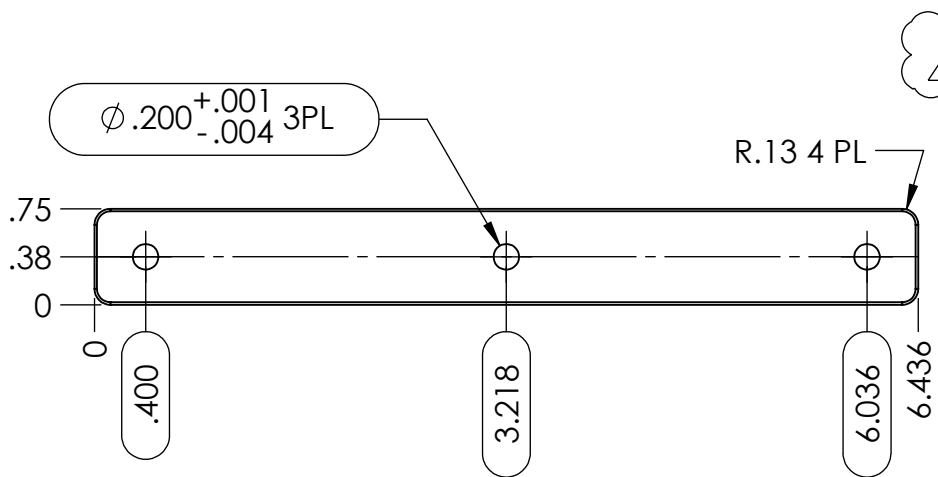
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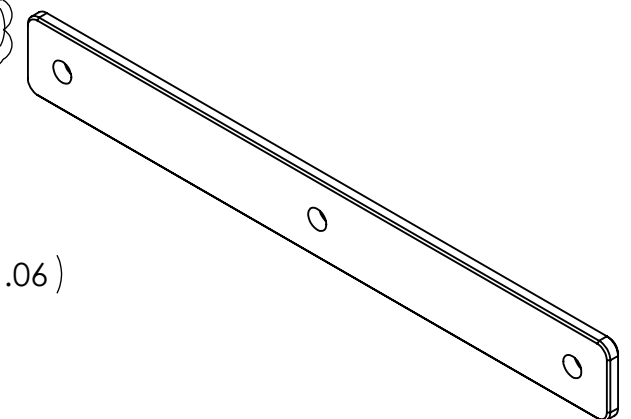
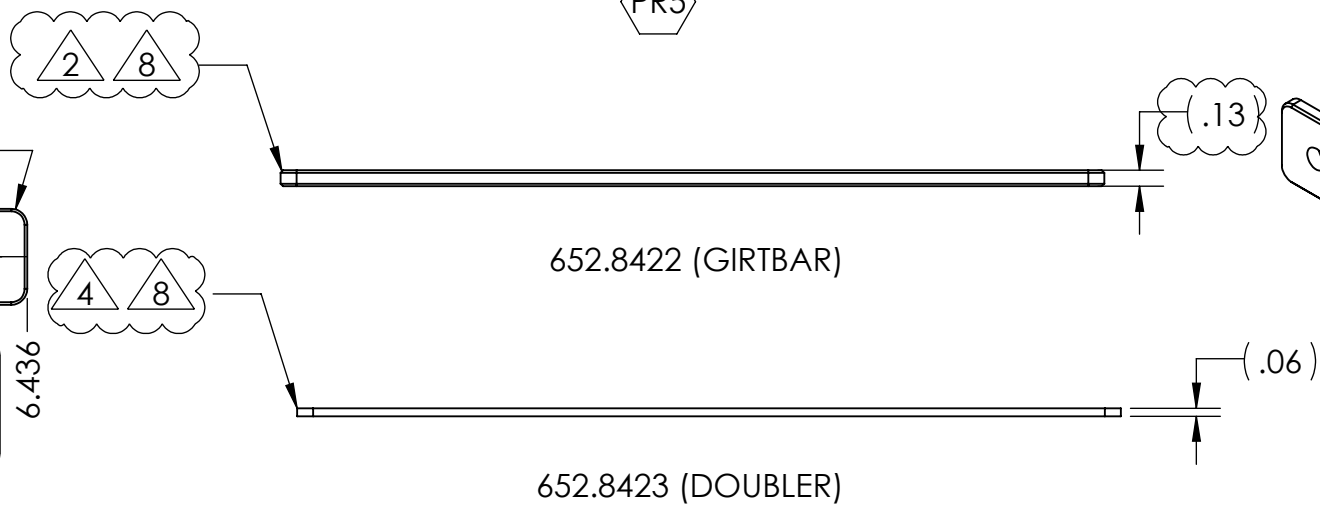
TOP VIEW 652.8420 & 652.8421



652.8420 SHOWN 9 10
652.8421 SIMILAR



TOP VIEW 652.8422 & 652.8423



652.8422 SHOWN 11 12
652.8423 SIMILAR

ORIGINAL DATE (MO-DA-YR) 10-16-19		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
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DRAWING APPROVAL J. GARDINER 10-16-19		AW189 SHEET METAL	
CONTRACT No.		SIZE B	REV. PR5
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		SCALE NONE	SHEET 4 OF 5

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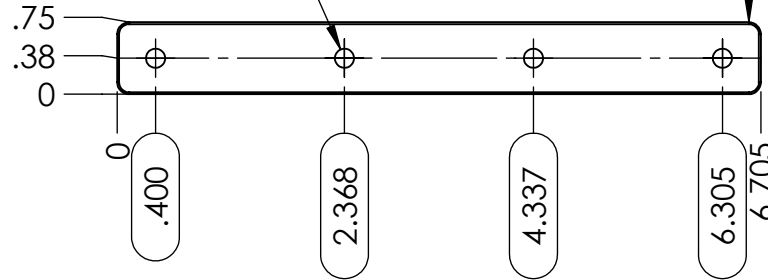
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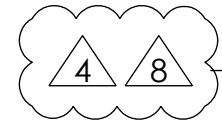
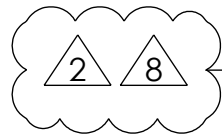
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$\phi .200^{+.001}_{-.004}$ 3PL

R.13 4PL



TOP VIEW 652.8424 & 652.8425



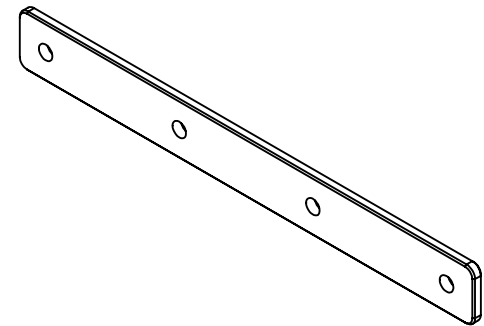
PR5

(.13)

652.8424 (GIRTBAR)

(.06)

652.8425 (DOUBLER)

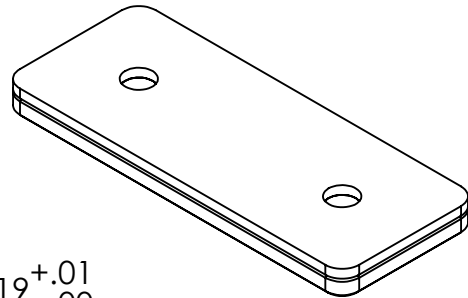


652.8424 SHOWN
652.8425 SIMILAR

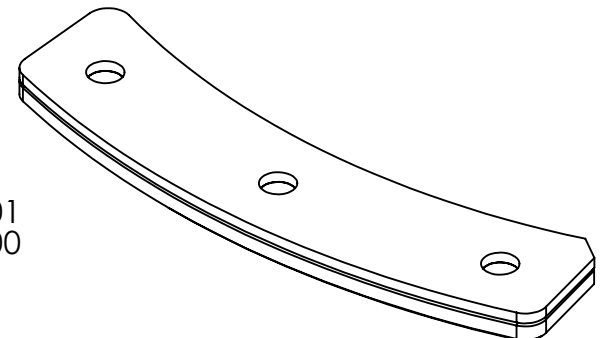
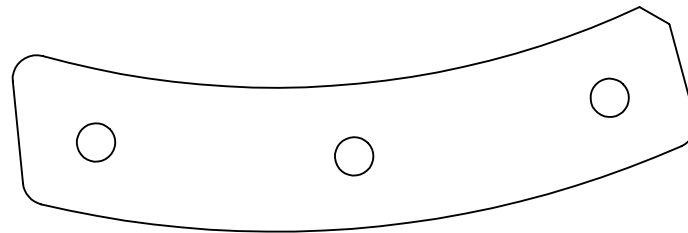
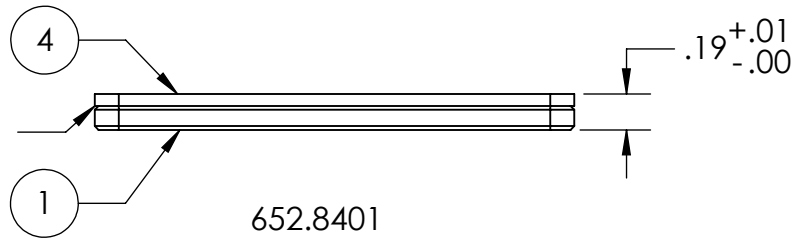
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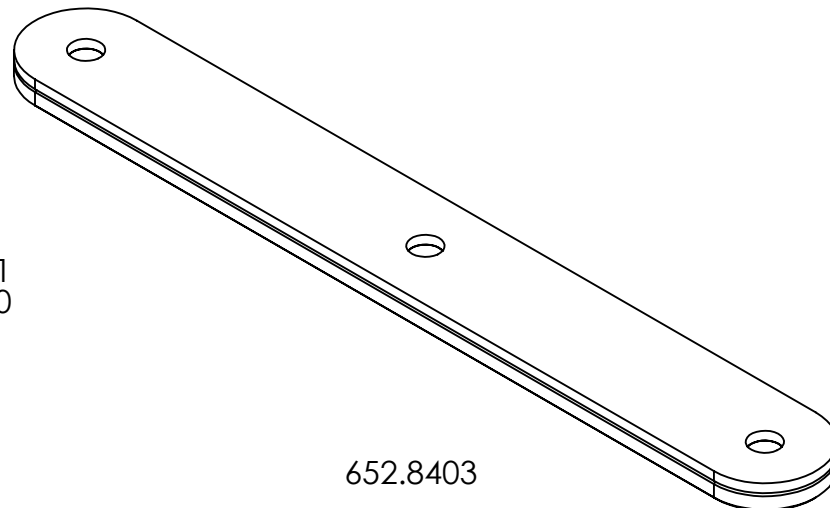
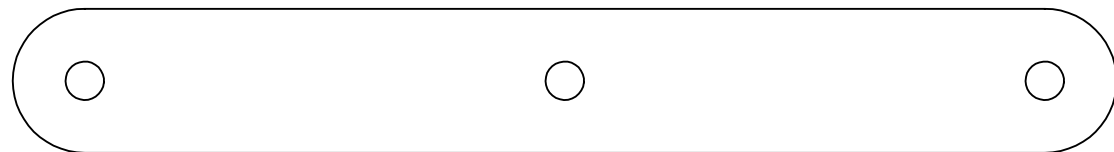
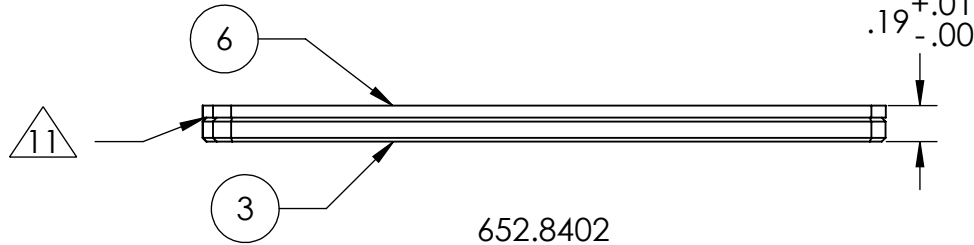
PR5



652.8401



652.8402



652.8403



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		CAGE CODE 07MZ6	DWG. NO. 652.8400
		SCALE NONE	SHEET 5 OF 5